

# Work Order ID 58325

Monday, May 03, 2010 11:43:28 AM



Page 1

Item ID: D3915-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Light Lid Assembly, Long Basket

Start Date: 5/3/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-5-3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3915

B

100



Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch: 112860 0.00

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3915. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.

\*\*\*DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME\*\*\*

2- weld hinge, label plate and Mounting plates as per dwg D3915

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.00

1 φ

PE 10.05.06

1 0 BE 10/05/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 58325**

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Start Date: 5/3/2010 Start Qty: 1.00

Required Date: 5/14/2010 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

8/10/06

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

\*\*\*ENSURE TO RINSE CAREFULLY ACID AND ALODINE\*\*\*

140

Weld per dwg A/R Aluminum rod Batch: 1112860.00

0.00

Large Fab

Memo

0.00

Large Fab

1- weld (4) corners

W/O:		WORK ORDER CHANGES					
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Required Date: 5/14/2010 Req'd Qty: 1.00



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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

1

0

2E10/05/06

155

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

S w l o s / o e

f e o

\*\*\*inspect fit of lid with base\*\*\*

E F 07-00 S w l o s / o e

157

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1- realodine corners  
\*\*\*do not acid etch\*\*\*

① B 10-5-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Monday, May 03, 2010 11:43:28 AM



Page 4

Item ID:	D3915-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Light Lid Assembly, Long Basket					
Start Date:	5/3/2010	Start Qty:	1.00		Cust Item ID:	
Required Date:	5/14/2010	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--



Powdercoat

Powder Coating

Memo

11114207

0.00

- 1- touch up corner with alodine only
- 2- Plug holes prior to

=> M 10/05/06

x1 0

1ST COAT:  
START TIME: 1:15pm  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 1:45pm

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT:  
START TIME: /  
OVEN TEMPERATURE: a/a  
FINISH TIME: /

170	QC3- Inspect Part Finish	0.00
-----	--------------------------	------



QC

Quality Control

Memo

0.00

9/10/05/07 0

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

Assemble as per dwg

0.00

HandFinish

Memo

0.00

Hand Finishing

1- Install webbing as per dwg

2- Install placard and label as per dwg

190

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

200

Identify as per dwg &amp; Stock Location:

0.00

Packaging

Memo

0.00

Packaging

6A  
6/05/07  
6050317~~to 56317~~  
~~D3915-041~~  
~~D4030-013~~

6/05/07

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 5/14/2010 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/07 *[Signature]*  
mf  
10-5-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 58325

Parent Item: D3915-041

Parent Item Name: Light Lid Assembly, Long Basket







Start Date: 5/3/2010

Required Date: 5/14/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as  
per dwg revB DD 10.04.20 verified by:EC IPP Rev:B add realodine DD  
10.04.26 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
D2728-1		Manufactured	No			180	Each	0.0000	1			
												
Dart Logo label												
D2957		Manufactured	No			100	Each	15.0000	4			
												
Mounting Plate												
<div> <div>Location</div> <div>WA</div> <div>57697</div> </div> <div> <div>Loc Qty</div> <div>15</div> <div>15</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>												
D3915-1		Manufactured	No			100	Each	0.0000	2			
												
Rib												
D4016-5		Manufactured	No			100	Each	12.0000	3			
												
Hinge Half, Light Lid												
<div> <div>Location</div> <div>ENG</div> <div>56075</div> <div>ST109</div> <div>57293</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> <div>10</div> <div>10</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>												
D4019-3		Manufactured	No			100	Each	0.0000	3			
												
Rib												
D4029-041		Manufactured	No			180	Each	2.0000	1			
												
Webbing (Long Basket)												
<div> <div>Location</div> <div>st503</div> <div>56963</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>												



EP 10/05/07

PL 10.05.05

4  
58301=1  
PL 10.05.05 358303=1

PL 10.05.05

3  
PL 10.05.05 358305

EP 10/05/07

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Monday, May 03, 2010 11:43:27 AM

[illegible][illegible]**Required Date: 5/14/2010**

**Required Qty: 1.00**

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
D4035-045		Manufactured	No			100	Each	0.0000	1			
												
Lid Rib Assembly, Fwd (Light)												
D4035-047		Manufactured	No			100	Each	0.0000	1			
												
Lid Rib Assembly, Aft (Light)												
D4056-1		Manufactured	No			100	Each	2.0000	1			
												
Label Plate												
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>												
<div> <div>WA</div> <div>2</div> <div></div> </div>												
<div> <div>56661</div> <div>2</div> <div></div> </div>												
D4086-220		Manufactured	No			180	Each	6.0000	1			
												
Placard, Max Load												
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>												
<div> <div>ST112</div> <div>6</div> <div></div> </div>												
<div> <div>56979</div> <div>6</div> <div></div> </div>												
MS20600-AD4W3		Purchased	No			180	Each	1,891.000	34			
												
Cherry Rivets												
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>												
<div> <div>ST321</div> <div>1891</div> <div></div> </div>												
<div> <div>106375</div> <div>3</div> <div></div> </div>												
<div> <div>107939</div> <div>888</div> <div></div> </div>												
<div> <div>111636</div> <div>1000</div> <div></div> </div>												

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Monday, May 03, 2010 11:43:27 AM

Page 3

Work Order ID: 58325



Parent Item: D3915-041



Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 5/3/2010

Required Date: 5/14/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as  
per dwg revB DD 10.04.20 verified by:EC IPP Rev:B add realodine DD  
10.04.26 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
NAS1149DN416J		Purchased	No			180	Each	270.0000	34			



Washer



*Ep 10/05/07*

Location

Loc Qty

Loc Code

ST	4	
13910	4	
ST275	166	
114340	166	
ST298	100	
114348	100	

*34*

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

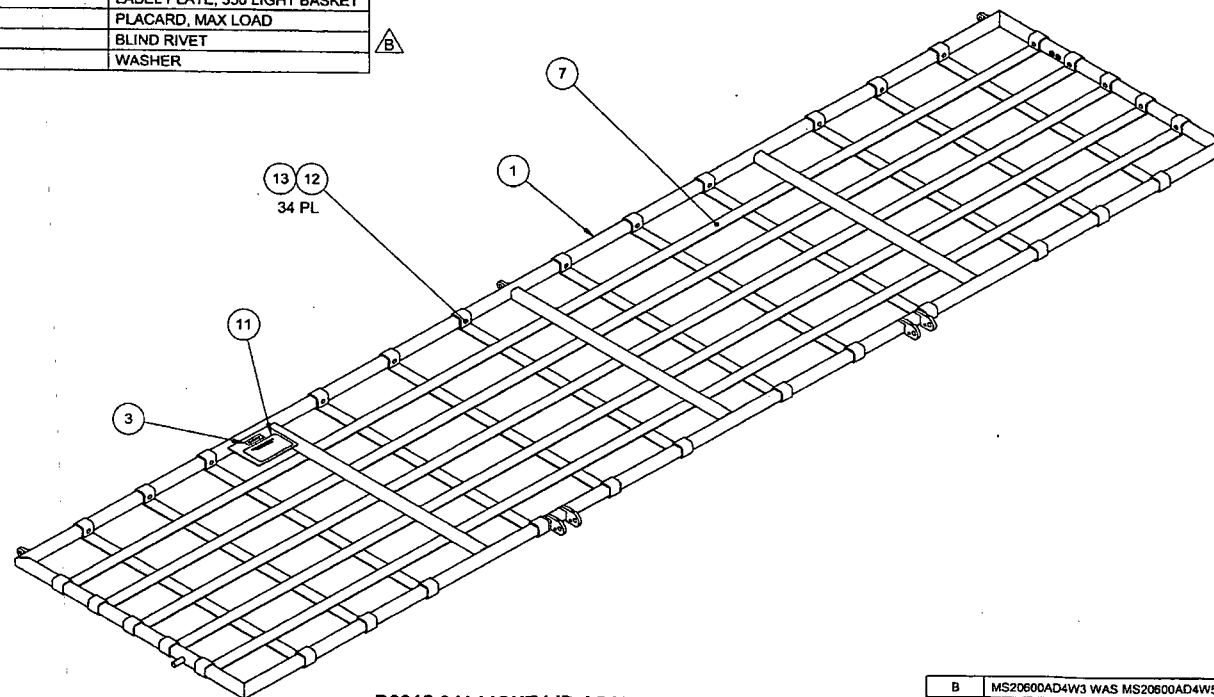
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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ITEM	QTY -041	QTY -101	P/N	DESCRIPTION
	X		D3915-041	LIGHT LID ASSY, LONG BASKET
1	1	X	D3915-101	BASKET LID WELDMENT ASSY
2		2	D3915-1	RIB
3	1		D2728-1	DART LOGO LABEL
4		4	D2957	MOUNTING PLATE
5		3	D4016-5	HINGE HALF
6		3	D4019-3	RIB
7	1		D4029-041	WEBBING (LONG BASKET)
8		1	D4035-045	LID RIB ASSY, FWD
9		1	D4035-047	LID RIB ASSY, AFT
10		1	D4056-1	LABEL PLATE, 350 LIGHT BASKET
11	1		D4086-220	PLACARD, MAX LOAD
12	34		MS20600AD4W3	BLIND RIVET
13	34		NAS1149DN416J	WASHER



**D3915-041 LIGHT LID ASSY, LONG BASKET ASSY**

**RELEASED**  
2010-04-16  
MD

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.91 lbs

B	MS20600AD4W3 WAS MS20600AD4W5: BOM & (B1-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GP	DRAWING NO.	REV. B
MFG. APPR.		D3915	SHEET 1 OF 4
APPROVED	MD	TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKET	INTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBOD OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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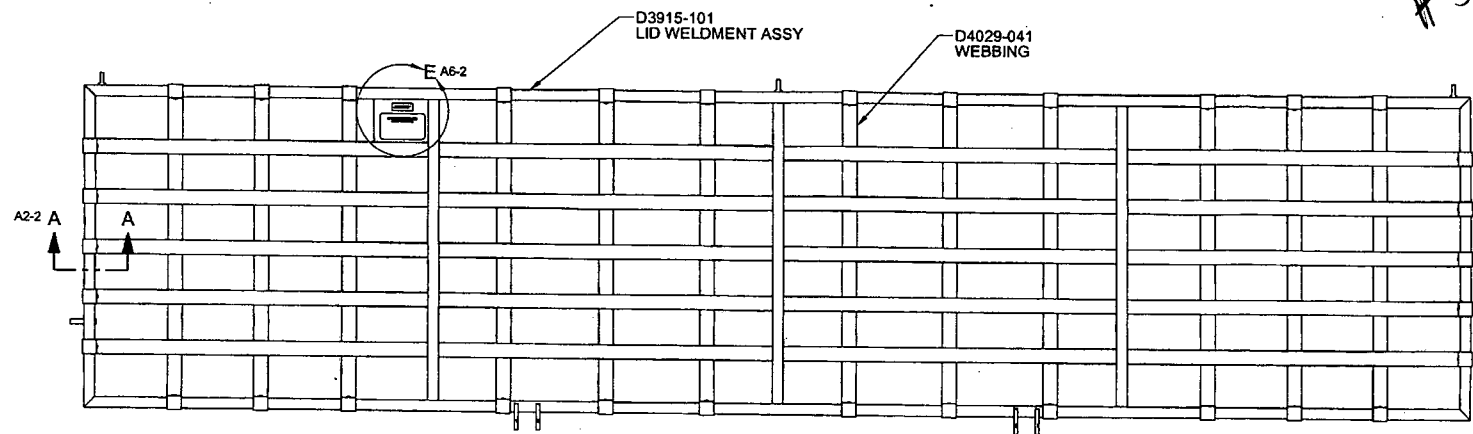
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

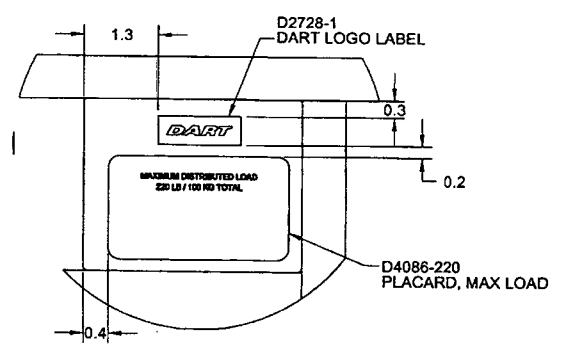
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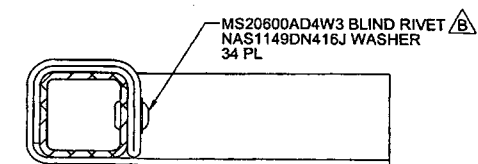
#58325



**D3915-041 LIGHT LID ASSY, LONG BASKET**







**VIEW E D6-2**



**SECTION A-A C8-2**

**RELEASED**  
2010-04-14

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESSBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3915	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>LIGHT LID ASSY-LONG BASKE INTs</b>	
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries